Work Orde	er ID 114040 2:40:50 PM			*114040*									
Item ID: Revision ID: Item Name:	D3651-041 Aft Base Assembly			Accept	*N900	1 040	100) * s	Setup Sta	17	IS1* IS2*		
Start Date: 3/03/14 Series Series Start Date: 3/17/14 Required Date: 3/17/14		Qty: 1.00 Qty: 1.00	*1* *1*		Cust Item ID: Customer:					7.0	. 17		
Reference: Approvals:	Process Plan:	ルゴ	Date: 14-03-03	Tooling: SPC (Y/N):	Date:			R	Run Sta Sto	/! ^	R1* R2*		
Sequence ID/ Work Center II	Opera D Descri			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
Draw Nbr	Revision N	or /			of street and the street and stre								
D3651	Rev B								•				
100	Pick Kit			0.00									
100 Packaging Packaging		Memo	×	0.00					}	F 14-	-09-15		
110				0.00			•						
110 Small Fab	Small Fa	b Memo		0.00				1		FF 14	1-09-15		
Small Fab		1-Assemble Proseal 700 D3651-1 u	e as per dwg D36512- Seal al 0 fire wall sealant as per dwg sing 3M high per formance co ch: 1105623	D3651Batch: M 196	138 3-install								
120 *1 <i>2</i> 0*	QC5- Ins	spect part comp	pleteness to step on W/O	0.00			DAS 30 9-89	7			iyloal		
QC		Memo		0.00			3 -03						

Quality Control

DQA:	Date:											TO AC.					
QA Closed:		Data			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only												
QA Closea:		Date:			,	_			VV	ork Order up	date only		 -				
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS										
				_	Rework	1		Skid-tube Crosstube	Г]	Water Jet		Engineering				
Part N	lo.				Scrap	Machining Small Fab Prod. Eng. Coor.							Quality				
					Use-as-is			noforming Finishing		Rec/Store/Packaging			Other				
NCR N	10				Suspected Unapproved			Large Fab Composite			Supplier						
Book					ription of work order update		nitial	Action		Sign &	<u> </u>	Т					
Root Cause	Date	1 1 1		Desci	or non-conformance	1	iiiliai iief Eng			Date	Verification		QC Inspector				
Design	Date	3tep	Qty		of non-comormance		HEI ENG	Description		Date	Vernication	╁	QC IIISPECTOI				
Doc/Data		-															
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Handling/Pre		1				1]							
Material																	
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Supplier		1															
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						FAI	ULT CA	TEGORY									
Landi	ng Gear				General					-	_						
	Bendin	g			Bend		Folio/F	Program	<u></u>	Outside Dim	ensions	P	ressure/Forced				
	Centre	Not Conce	ntric		BOM/Route	L	Grain			Over/Under	tolerance	_	et-up				
	Cracks				Broken/Damage/Defect		Hardwa		\vdash	Part Incorre	-	_	emperature/Cure				
		Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified	<u></u>	Part Lost/M	issing	_	Veld				
	Cuffs			<u> </u>	Contamination		1	tions Incomplete/Unclear		Part Moved		\^	Vrong Stock Pulled				
	Crushing				Countersink	<u></u>	4	gned/off center		Positioned V	· -	_					
	Heat Tréat			<u> </u>	Cut Too Short		Mislab			Power Loss/	Surge	lo	ther				
,	Inspection Strip in Tube			<u> </u>	Drawing		Misrea										
					Drill Holes	<u></u>	Off-set										
	_	g Sequence		<u> </u>	Finish	<u></u>	-	Calibration					· · · · ·				
	Wave/	Twist in Tu	be		Fit/Function	1	Out of	Sequence									

Work Orde March-03-14 12		14040		*112				Page 2				
Item ID: Revision ID: Item Name:	D3651-041 Aft Base Ass	embly		Accept	*N900040100*					Start Stop	I VI	S1* S2*
Start Date: Required Date: Reference:	3/03/14 3/17/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Date:]	Run	Start Stop		R1* R2*
Sequence ID/ Work Center II 130 *120* Packaging Packaging)	Operation Description Identify as per dwg & Sto	ock Location: GA	Set Up/ Run Hours 0.00	Tool ID		Plan Code AS O 89	Accept Qty	Reje Qty		Reject Number	Insp. Stamp

0.00

0.00

140

140

Quality Control

QC21- Final Inspection - Work Order Release

Memo

H249-16

DQA:	Date: WORK ORDER NON-CONFORMANCE / UPDATE										TOART			
QA Closed:		Date:			WORK ORDER NON	-C(ONFOI	RMANCE / UF		ork Order up	odate only	AEROSPACE		
					DISPOSITION									
Work Orde	r:					,				PARTMENT,		🗂		
Daint Al					Rework			Skid-tube	Crosstube	ļ	Water Jet	Engineering		
Part N	o				Scrap		1	Machining	Small Fab Finishing	-4	d. Eng. Coor. re/Packaging	Quality Other		
NCR N	0				Use-as-is Suspected Unapproved		mern	noforming Large Fab	Composite	Kec/stor	Supplier			
NCK IV	·			_	Suspected Onapproved]		raige rab	Composite		Supplie!	! <u> </u>		
Root		Desc		Desc	ription of work order update		Initial	Acti	ion	Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector		
Design														
Doc/Data		1												
quip/Tooling														
landling/Pre	_										,			
Material			ļ			ł								
Operator														
Offset/Setup		Ì												
Process														
upplier														
raining	_													
ransport														
Inapproved			<u> </u>			<u> </u>				<u> </u>		<u> </u>		
						FA	ULT CAT	regory	<u> </u>					
Landin					General	_	.			7	_	1		
	Bending				Bend		-1	rogram		Outside Dim		Pressure/Forced		
-	Centre No	ot Conce	ntric		BOM/Route	_	Grain		·	Over/Under	·	Set-up		
-	Cracks			\vdash	Broken/Damage/Defect	<u></u>	Hardwa			Part Incorred		Temperature/Cure		
-	Crimp/Kir	nk/Ripple	e/Wave		Burrs	<u> </u>	4	ion Incomplete/Un	· -	Part Lost/Mi	ssing	Weld		
-	Cuffs			<u> </u>	Contamination	\vdash	-	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled		
•	Crushing			<u> </u>	Countersink			ned/off cénter		Positioned V	_	Jan		
-	Heat Trea		~ 1		Cut Too Short	\vdash	Mislabe		_ · _ <u>L</u>	Power Loss/	Surge	Other		
, -	Inspection	-	Drawing	_	Misread									
	Marks/Chatter Drill Holes Turning Sequence Finish						Off-set	M						
-	_			-	Finish	-	-1	Calibration						
1	Wave/Tw	ust in Tul	oe -		Fit/Function	1	JUUT of 3	Sequence						

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Picklist Print

March-03-14 12:40:53 PM

Work Order ID: 114040

114040

Parent Item:

D3651-041

D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 3/03/14

Required Date: 3/17/14

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 07-09-27

DD verified by: EC IPP Rev:B ECN 1113P 08-01-22 DD verofoed by: EC

IPP Rev:C ecn1162

08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Rout Seq 1		Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CR3523-4-02		Purchased	No			100		Each	620.0000	58	58			
CR3523-	4-02									**		FF	14	-09-15
				Location	<u>1</u>		Loc Oty		Loc Code					•
				GA			133	2		_				
					m124198		133	2		_	58	_		
				ST330			488	8	•					
					m126826		488	8				_		
D3651-043		Manufactured	No			110	1	Each	9.0000	1	1			
D3651-04	43									**		FF	10	1-09-15
				Location	<u>1</u>		Loc Oty		Loc Code					
X				ST189			9	9						
•					109743			1				_		
					94016		8	8		_		_		
D3651-1		Manufactured	No			110	1	Each	12.0000	1	1			•
D3651-1 Gasket	k				·				•	**		FF	14	-09-15
				Location	<u>1</u>		Loc Oty		Loc Code					
				ST188			13	2				·		
					95811		12)	-		

DQA:		. Date:			- DART											
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only											
Work Orde	r:				DISPOSITION											
Part N	0				Rework Skid-tube Machining Thermoforming Large Fab				Crosstube Small Fab Finishing omposite	Pro Rec/Stor	Engineering Quality Other					
Root				Desci	ription of work order update		Initial	Action		Sign &						
Cause	Date	Step	Qty		or non-conformance	1	ief Eng	Description	on	Date	Verification	QC Inspector				
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved								^								
						FAI	ULT CAT	TEGORY								
Landin	Bending Centre No Cracks Crimp/Kir				General Bend BOM/Route Broken/Damage/Defect Burrs		Grain Hardwa	Program are ion Incomplete/Unqua	alified	Outside Dim Over/Under Part Incorrec Part Lost/Mi	tolerance	Pressure/Forced Set-up Temperature/Cure Weld				
	Cuffs Crushing Heat Trea		,		Contamination Countersink Cut Too Short		Instruct	tions Incomplete/Uncle gned/off center	<u> </u>	Part Moved Positioned W Power Loss/	/rong	Wrong Stock Pulled Other				
	Inspection	n Strip in	Tube		Drawing		Misread	d								
. [Marks/Chatter Turning Sequence				Drill Holes Finish		Off-set Out of (Calibration								
	□Wave/Tw	ist in Tub)e		Fit/Function		Out of	Sequence								

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March-03-14 12:40:53 PM

114040 Work Order ID: 114040 Parent Item: D3651-041 *D3651-041* Parent Item Name: Aft Base Assembly **Start Date: 3/03/14** Required Date: 3/17/14 Start Qty: 1.00 Required Qty: 1.00 6.0000 D3651-11 Manufactured 110 Each FF 14-09-15 ** *D3651-11* Loc Code Loc Qty Location GA 6 94796 6 12.0000 D3651-13 Manufactured 110 Each FF 14-09-15 ** *D3651-13* Outside Doubler Location Loc Qty Loc Code GA 2 2 94690 ST187 95403 ST188 9 95404 9 5.0000 D3651-9 110 Each Manufactured FF 14-09-15 ** Inside Doubler Location Loc Qty Loc Code GA 94595 1 ST188 95376

DQA:		Date:			DART											
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only											
Work Orde					DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part N				<u> </u>	Rework Scrap Use-as-is		1	Machining	Crosstube Small Fab	1	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality				
NCR No.					Suspected Unapproved		Inem	noforming C	Finishing	Rec/Stor	Other					
Root	Des			Desci	cription of work order update		Initial	Action)	Sign &						
Cause	Date	Step	Qty	2	or non-conformance	Ch	nief Eng	Descript	ion	Date	Verification	QC Inspector				
Design Doc/Data																
quip/Tooling		,														
landling/Pre																
Material																
Operator				<u>.</u>								,				
Offset/Setup																
Process																
upplier																
raining									•							
ransport		İ			,			-								
Jnapproved																
						FAI	JLT CA	TEGORY				-				
Landin	g Gear				General		_			_						
, L	Bending		•		Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced				
Ĺ	Centre No	ot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up				
L	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	:i	Temperature/Cure				
	Crimp/kir	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqu	alified	Part Lost/Mi	ssing	Weld				
	Cuffs				Contamination		Instruct	tions Incomplete/Uncl	lear	Part Moved		Wrong Stock Pulled				
	Crushing				Countersink		Misalię	ned/off center		Positioned W	/rong					
	Heat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/:	Surge	Other				
	Inspection	Strip in	Tube		Drawing		Misread	d								
	Marks/Ch	atter			Drill Holes		Off-set									
	Turning S	equence			Finish		Out of (Calibration								
	Wave/Tw	ist in Tub	oe		Fit/Function Out of Sequence											